



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3511
Job Sheet 168236



Part No: 646.3511

Job Qty: 6 ea

Part Name: Strut



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 12/1/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV N/C 3 IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		11/30/17	0.00	0.00	Start Up Large Fab-1		SC
110	Waterjet	6 pcs		11/30/17	0.00	0.24	Waterjet1		SC
120	QC	6 pcs		11/30/17	0.00	0.00	QC2		SC DAS
130	QC	6 pcs		11/30/17	0.00	0.00	QC8		SC 38
140	Small Fab	6 pcs		11/30/17	0.00	2.52	Small Fab		DYC 17/11/21
150	QC	6 pcs		11/30/17	0.00	0.00	QC5		FL
160	Large Fab	6 pcs		11/30/17	0.00	6.90	Large Fab 1		DYC 17/11/24
170	QC	6 pcs		11/30/17	0.00	0.00	QC9		D 17.12.4
180	QC	6 pcs		11/30/17	0.00	0.00	QC5		D 17.12.4
220	SprayPaint	6 pcs		12/1/17	0.00	0.28	Spray Paint		17.12.4-12-06
230	QC	6 pcs		12/1/17	0.00	0.00	QC14		38
240	Packaging	6 pcs		12/1/17	0.00	0.00	Packaging3	CLK103	38
250	QC21-SA	6 Ea		12/1/17	0.00	0.00	QC21		38

Part Op 110 - 1-Cut 646.3500 plate 2.75"x 1.50" as per Dwg

Descriptions: 140 - 1- Fabricate tube as per dwg USE DT10290 PUNCH

160 - Weld tube to plate as per dwg. DT9867

220 - Prime as per dwg (see note 3)

240 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S16GA	0	45	0	0
140-Small Fab	M304TR0.500W.049	5	41	0	0

Part Specifications

Specifications could not be found.

Plex 11/14/17 6:52 AM dart.boucher.sylvie

DART
AEROSPACE
S010285

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
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www.dartaerospace.com



Strut

PART NO: 646.3511

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 11/15/17

Job No: 168236

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 04274				SHEET 1 OF 1	
	DWG NO. 646.3500	REV: NC	PREPARED BY J. SOTO	DATE: 12/02/2013		EFFECT ON DWG ☐ INC. ☒ UNINC.
	DWG TITLE: STRUT					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF. NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REVISED DELTA NOTE 1 & 2.				

SHEET 1, ZONE A1 IS:

- IS** →
- NOTES:**
- 1 MATERIAL: AISI 304/ 316 SS SHEET .062 THK
(REF DART SPEC. M304S16GA)
 - 2 MATERIAL: AISI 304/316 SS 0.500 OD X 0.049 WALL
(REF DART SPEC. M304TR0.500W0.049)
ENSURE SEAMLESS TUBE IS USED
 - 3 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2
COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
 4. DEBURR AND BREAK ALL SHARP EDGES
 5. WELDS IAW MIL-STD-2219.
TIG WELD WITH FILLER ROD

DOCUMENTS EFFECTED:	☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM	CHANGE CATEGORY	DER REVIEW REQUIRED
		☐ MAJOR ☒ MINOR	☐ YES ☒ NO

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NOTES:

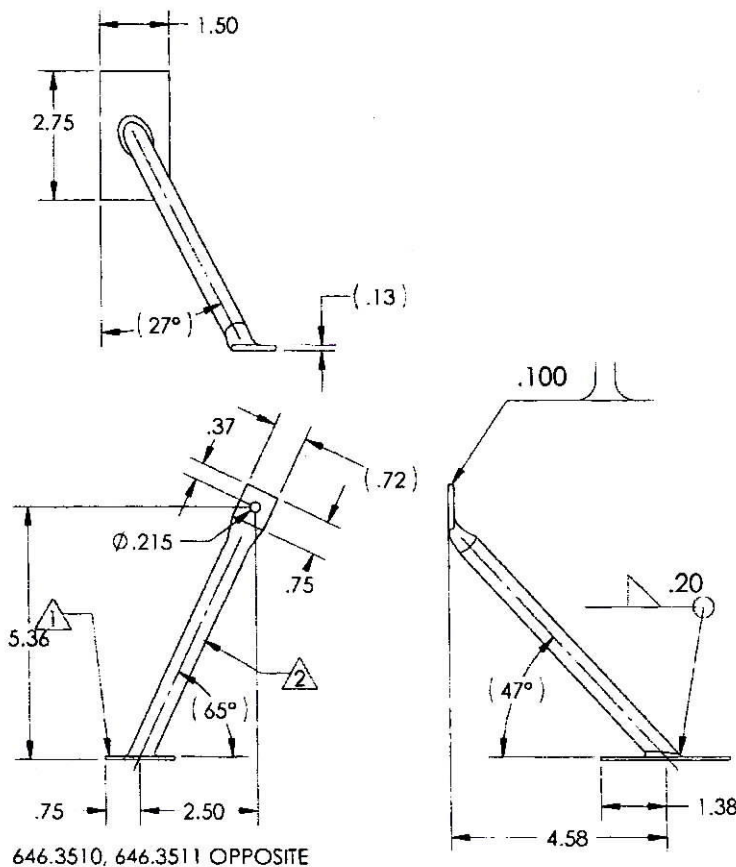
1 MATERIAL: 6061-T6 ALUMINUM IAW AMS-QQ-A-250/11;
.062" THK.

2 MATERIAL: 6061-T6 ALUMINUM IAW AMS-WW-T-700/6
.500" OD; .062" WALL THK

3 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2
COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N

4. DEBURR AND BREAK ALL SHARP EDGES

5. WELDS IAW MIL-STD-2219.
TIG WELD WITH FILLER ROD



646.3510, 646.3511 OPPOSITE

646.3510 SHOWN
646.3511 OPPOSITE

UNINCORPORATED ECN(s)

02197, 02440, 04274

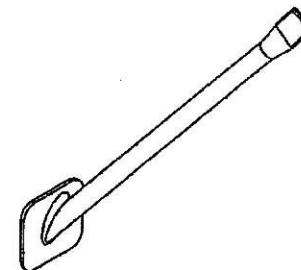
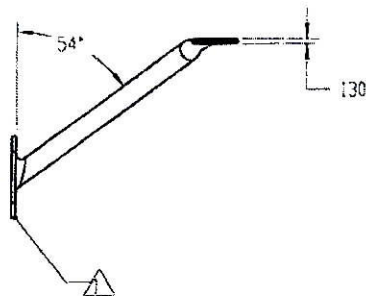
QTY	FIND #	PART #	DESCRIPTION	MATL	SPEC
		646.3513	STRUT	△△	△
		646.3512	STRUT	△△	△
		646.3511	STRUT	△△	△
		646.3510	STRUT	△△	△
PARTS LIST					
NEXT ASSY (S)			APICAL INDUSTRIES		
646.4000			2608 TEMPLE HEIGHTS DR.		
			OCEANSIDE, CA. 92056-3512 (760)724-5300		
			STRUT		
			SCALE: NONE		
			SHEET 1 OF 2		

APICAL
INDUSTRIES, INC.

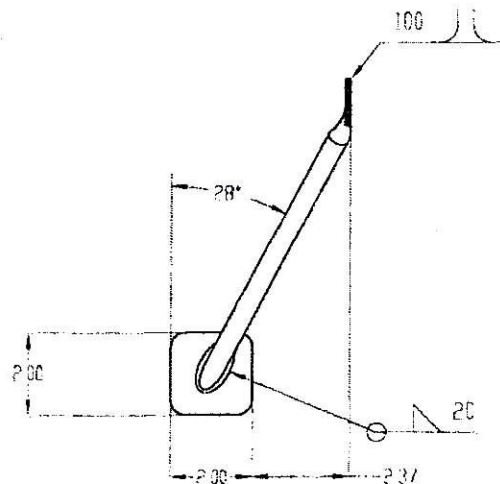
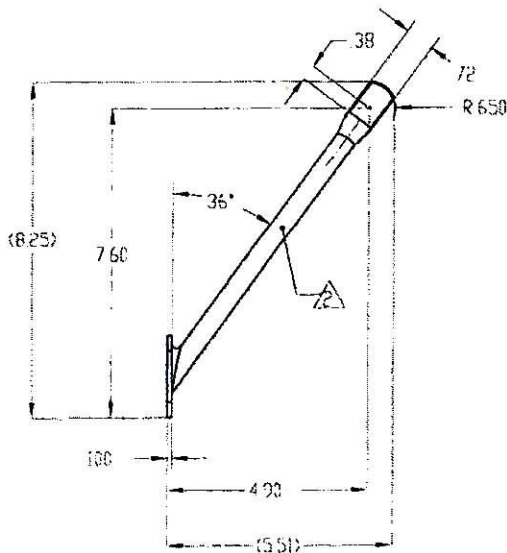
ENGINEERING CHANGE NOTIC. NO. 02440		SHEET 1 OF 1	
DWG NO. 646.3500	REV: NC	PREPARED BY S. HUFF	DATE 06/08/09
DWG TITLE: STRUT		EFFECT ON DWG ☐ INC. ☒ UNINC.	
APPROVED BY: ENGR [Signature]	MFG [Signature]	QC [Signature]	EFFECT: CURRENT ORDER AND STOCK
REASON: REVISED GEOMETRY TO ACCOMMODATE NEW EXISTING AIRCRAFT PROVISIONS			

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

SHEET 2 IS:



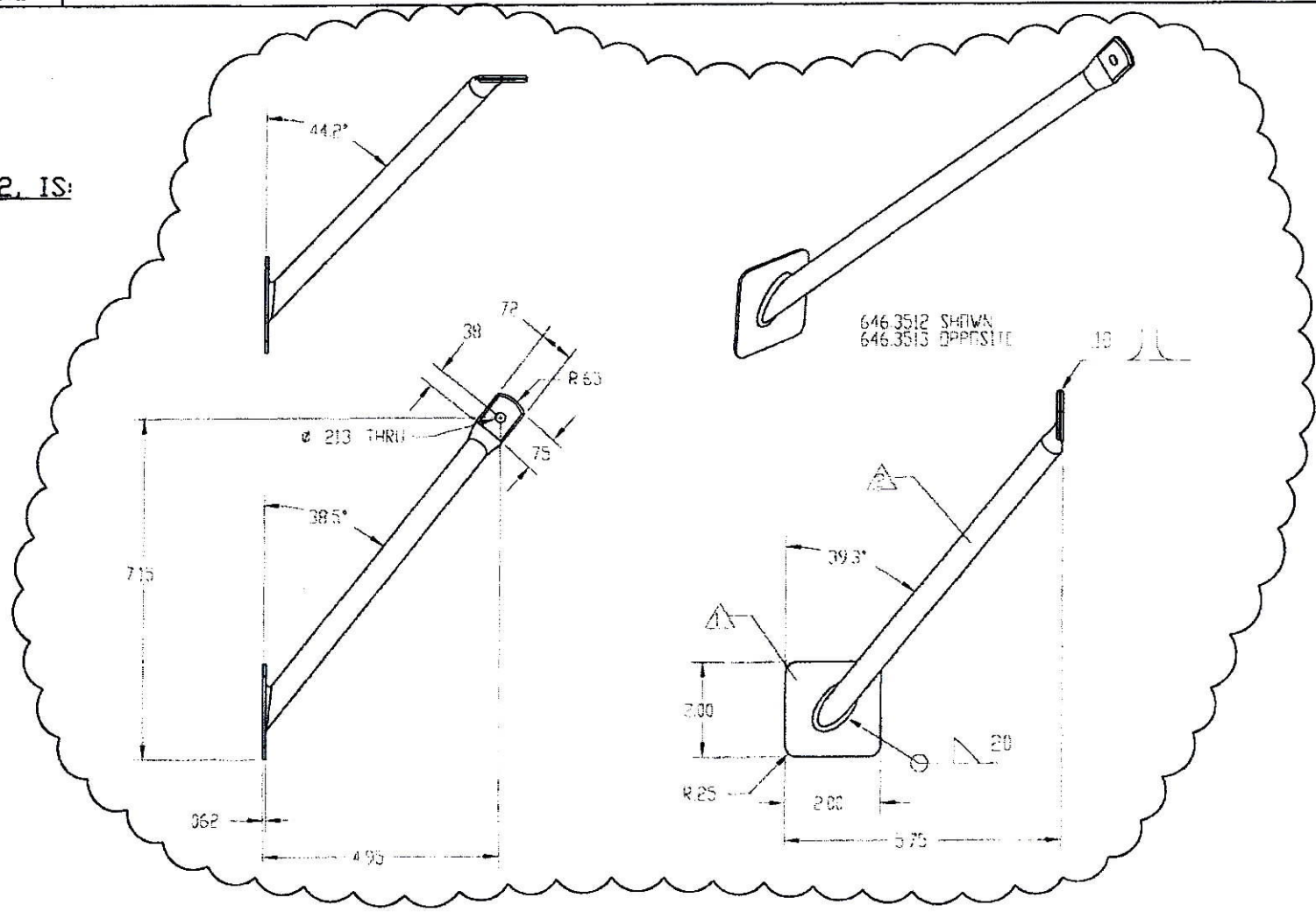
646.3512 SHOWN
646.3513 (PREVIOUS)



DOCUMENTS EFFECTED:	☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ FMS ☐ BOM	CHANGE CATEGORY	DER REVIEW REQUIRED
		☐ MAJOR ☒ MINOR	☐ YES ☒ NO

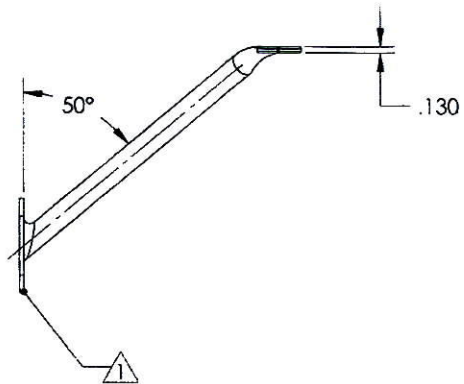
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02197			SHEET 1 OF 1	
	DWG NO. 646.3500	REV: N/C	PREPARED BY S. HUFF	DATE: 01/05/09	EFFECT ON DWG ☐ INC. ☒ UNINC.
	DWG TITLE: STRUT				
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF:	NEXT ORDER
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED ANGLE OF 646.3512 & 646.3513 FOR BETTER FITMENT				

SHEET 2. IS:

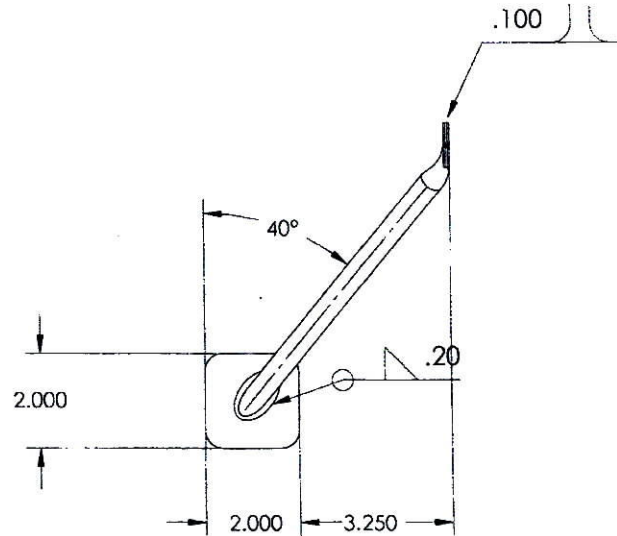
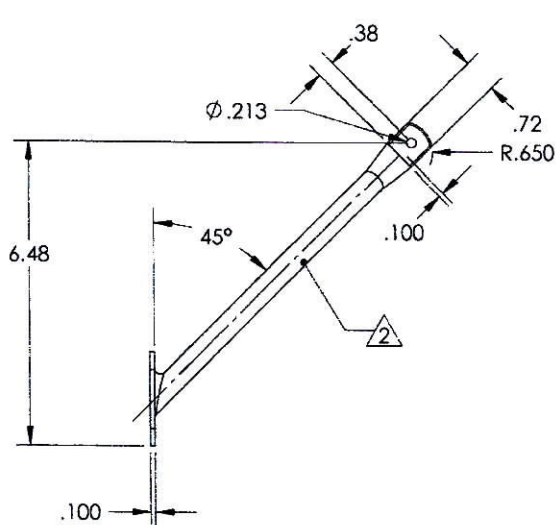


DOCUMENTS EFFECTED:	☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ FMS ☐ BOM	CHANGE CATEGORY	DER REVIEW REQUIRED
		☐ MAJOR ☒ MINOR	☐ YES ☒ NO

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646.3512 SHOWN
646.3513 OPPOSITE



QTY: 100 DATE: 08/28/08 DESIGNED BY: J. H. H. H. CHECKED BY: J. H. H. H. DRAWING APPROVAL: J. H. H. H. SCALE: NONE CONTRACT NO.:		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
STRUT		646.3500	
SCALE: NONE		SHEET 2 OF 2	

